

Date: Tuesday, 4/4/2006 1:32:31 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE SPACER
 Job Number : 26513
 Estimate Number : 10827
 P.O. Number : N/A
 This Issue : 4/4/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : 24897
 Written By : SEE COMMENT BELOW
 Checked & Approved By : 06.04.04
 Comment : Est B 00.05.19 Added inspect level 8 EC

Part Number : D2877
 Drawing Number : D2877 REV A
 Project Number : N/A
 Drawing Revision : A
 Material : NOTE:1 BLANK MAKES 4 PARTS
 Due Date : 5/5/2006 Qty: 120 Um: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M5052H32S100

5052-H32 .100 Sheet



Comment: Qty.: 0.5468 sf(s)/Unit Total : 65.6208 sf(s)
 Material: 5052-H32/H34 (QQ-A-250/8) 0.100" Thick
 Batch: M307 15830

2.0

SHEAR

SHEAR



Comment: SHEAR
 1 blank makes 4 parts
 Blank: 7.00" x 4.25" (+0.030" -0.000")

3.0

HAAS61

Water jet

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 CUT 1-Machine per lot D2877

Dwg Rev: REV A
 Prog. Rev: A

06-05-01 (120)

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06-05-01 (120)

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

06/05/05 (120)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Tumble
 Deburr any rough edges after tumbling

06:05:09 (120)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 2 Date: 06/05/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

Job Number: 26513

Part Number: D2877

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M.F. 06/05/09
H.M. 06/05/09

(58)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

U 6/5/11 (120)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 392

P 6/5/11 (120)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

P 06/05/12 (120)

Job Completion



U 06/05/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

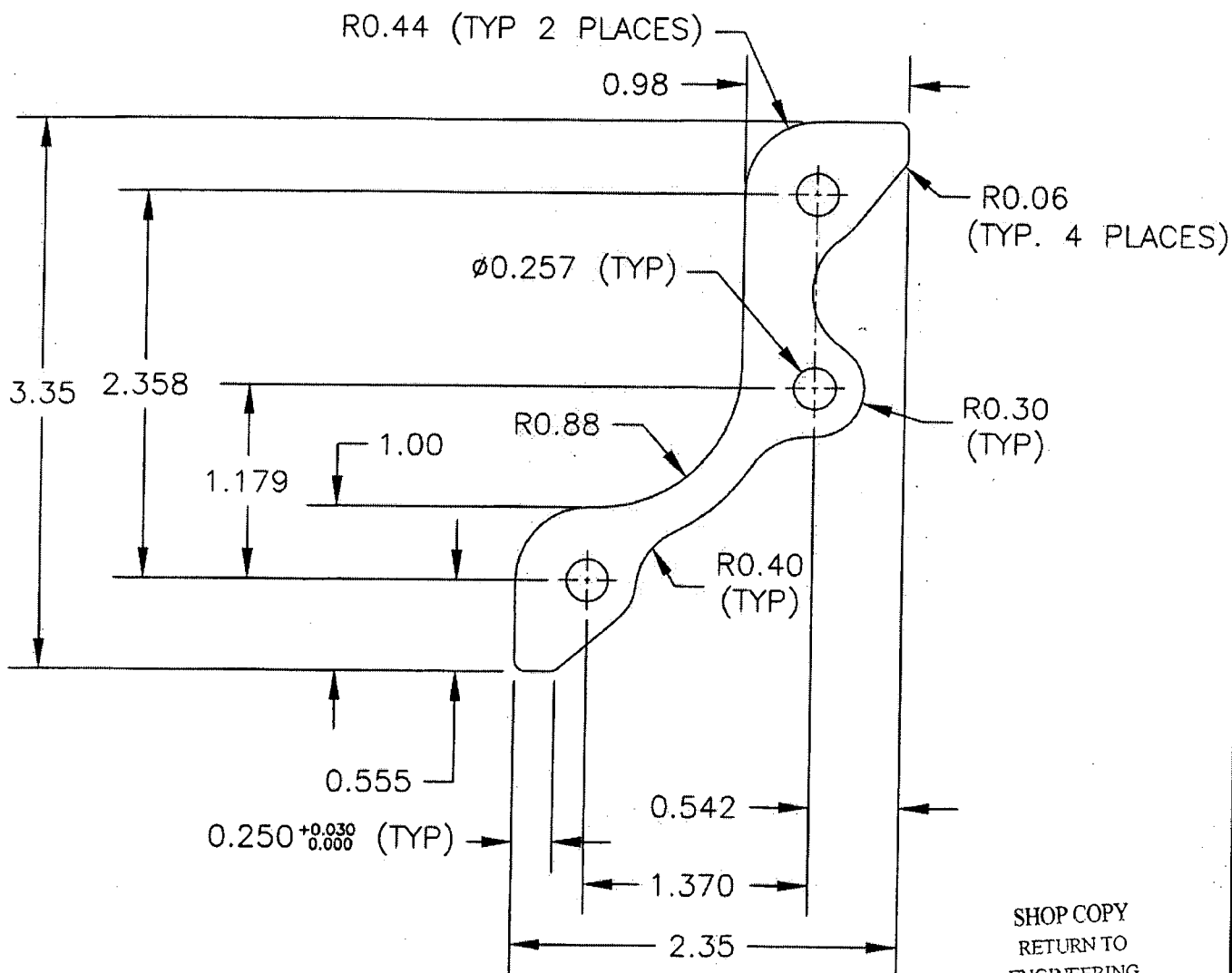
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2877	REV. A SHEET 1 OF 1
DATE	99.02.23		TITLE SADDLE SPACER		SCALE 1:1
A	99.02.23		NEW ISSUE		

RELEASED
99.04.27 15



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26513

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.100 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL SHARP EDGES 0.010 TO 0.020